

Resh ship 30-31/03

Work Order ID 67670

Tuesday, March 29, 2011 10:57:42 AM



Page 1

Item ID: D3195-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 3/29/2011 Start Qty: 1.00

Required Date: 3/30/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3195

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut blanks: (1.250" x 1.500") x 3.60" long

11/03/28

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3112-Deburr

11/03/28

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/03/28

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Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

OK 11/03/30

1

✓

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

1 BR 11-3-30.

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

10:30

OVEN TEMPERATURE:

320° FINISH TIME:

11:00

1 BR 11-3-30.

Work Order ID 67670

Tuesday, March 29, 2011 10:57:42 AM



Page 3

Item ID: D3195-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 11/03/30

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Lightly Sand bonding surface! 12-Bond D3195-7 into D3195-13as per Dwg
D3195: 1A/RContact Cement M111095

EB 11/03/30 ①

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5 11/03/30

④

Work Order ID 67670

Tuesday, March 29, 2011 10:57:42 AM

Page 4

Item ID: D3195-043

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 3/29/2011 Start Qty: 1.00

Required Date: 3/30/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

190

Identify as per dwg & Stock Location: *ST240* 0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

4/3/30 (1)

4/3/30
me
11-03-30

Picklist Print

Tuesday, March 29, 2011 10:57:39 AM

Page 1

Work Order ID: 67670

Parent Item: D3195-043

Parent Item Name: Bracket Assembly



Start Date: 3/29/2011

Required Date: 3/30/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3195-7		Manufactured	No			100	Each	8.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Pad

Location

Loc Qty

Loc Code

GA

8

51569

4

64534

4

M6061T6B1.500X01.25

Purchased

No

170

f

15.8000

0.3

0.315789

0



6061-T6 Bar 1.50 x 1.25

Location

Loc Qty

Loc Code

MAT004

15.8

107461

0.9

110936

14.9

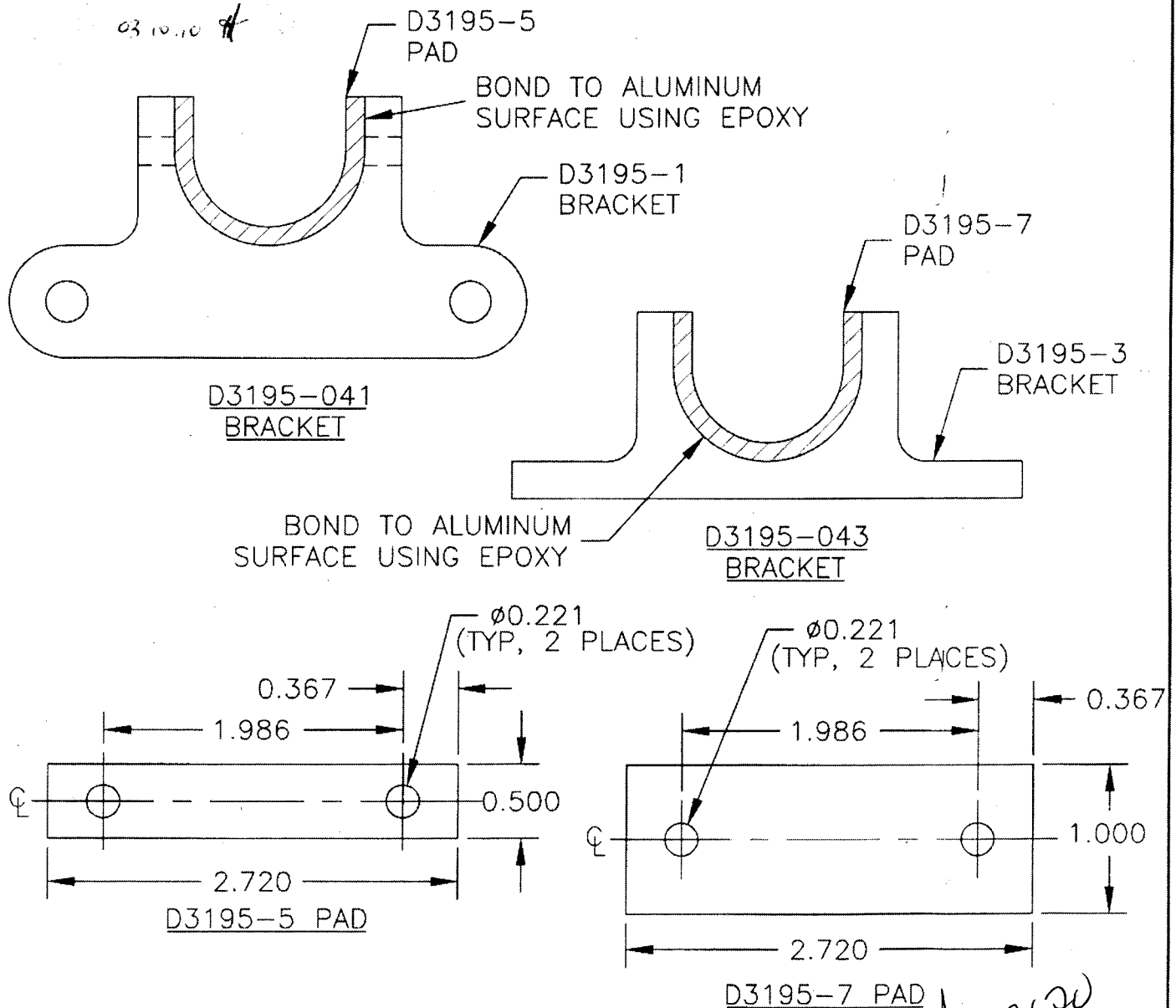


33 f

11/03/28



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE	03.06.23			TITLE BRACKET	SCALE 1:1
A	03.06.23			NEW ISSUE	



D3195-5 & D3195-7 PAD

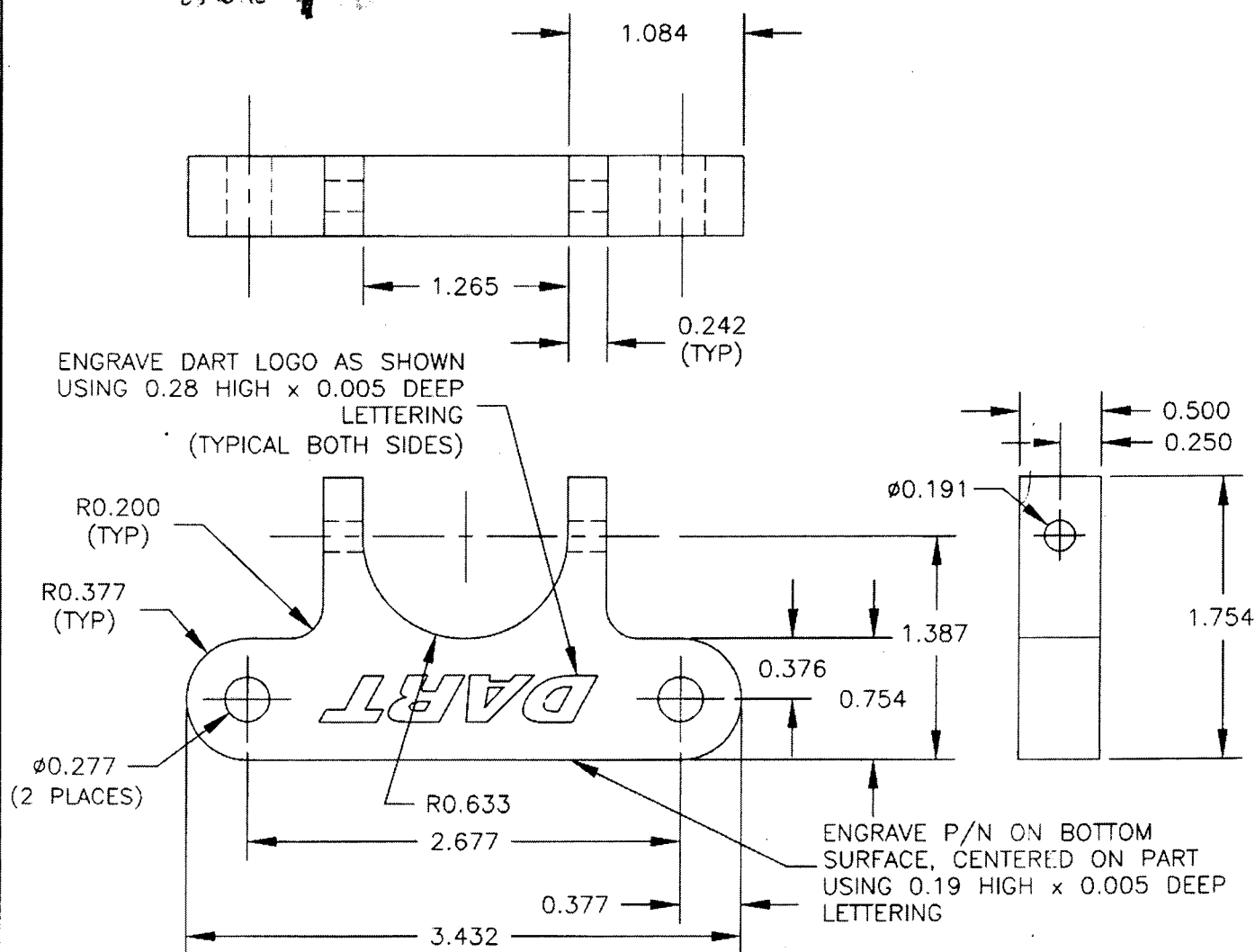
- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

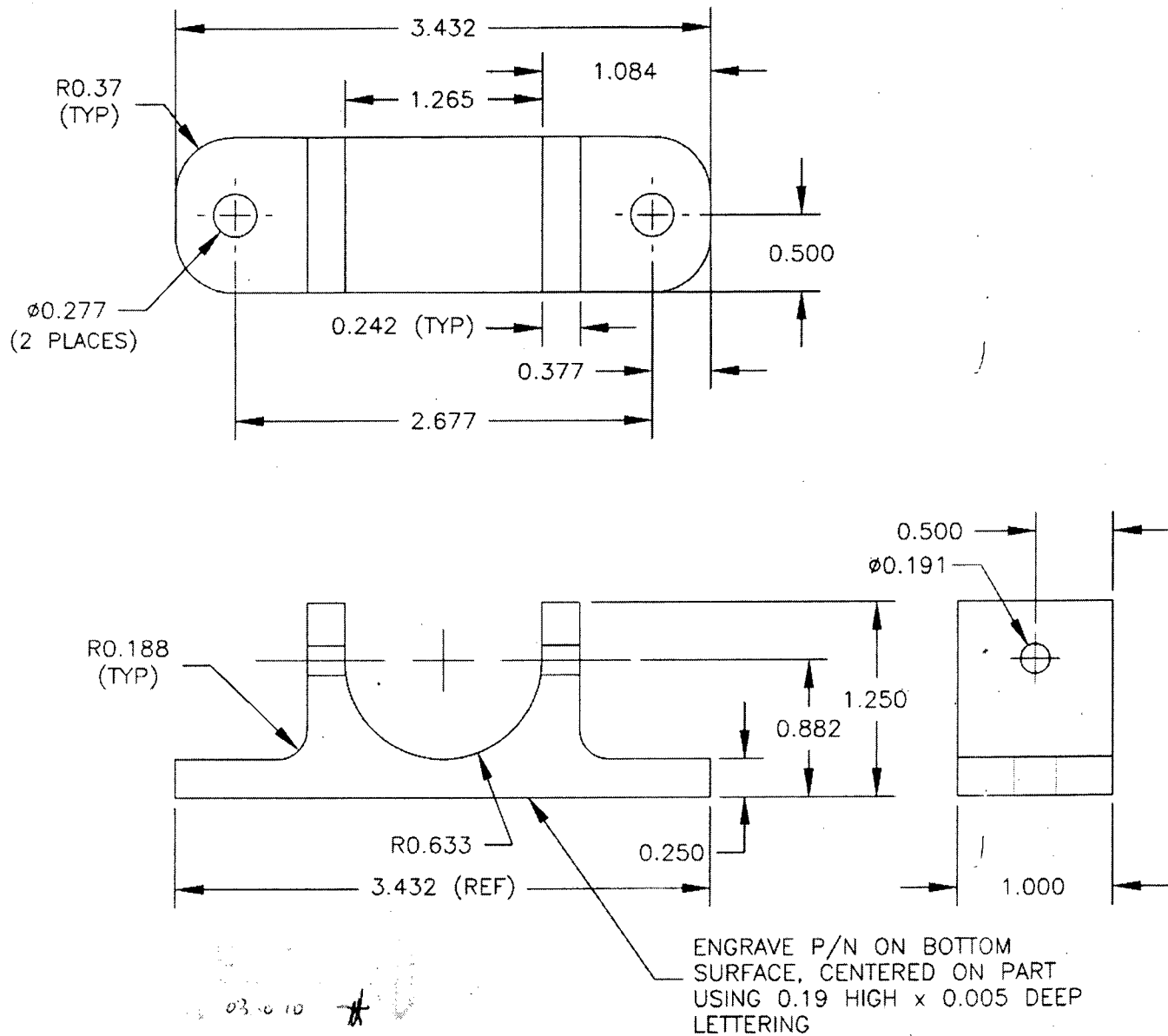
67670

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD		Work Order: 67670
Description: Bracket		Part Number: 3195-3
Inspection Dwg: 3195 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.432	$\pm .010$	3.434	—		RA26	Vern
1.265	$\pm .010$	1.267	—		"	
R0.37	$\pm .030$	R0.375	—		"	
$\phi .277$	$\pm .005$	0.277	—		"	
2.677	$\pm .005$	2.678	—		"	
.242	$\pm .010$.243	—		"	
.377	$\pm .010$.379	—		"	
.500	$\pm .010$.503	—		"	
R0.188	$\pm .010$	R0.1875	—		"	
.250	$\pm .010$.242	—		"	
.882	$\pm .010$.889	—		"	
1.250	$\pm .010$	1.247	—		"	
.500	$\pm .010$.494	—		"	
$\phi .191$	$\pm .005$.193	—		"	
1.000	$\pm .010$	1.003	—		"	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: 11/03/30	Date: 11/03/30	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	